

Date: Friday, 22/05/2009 8:58:45 AM
 User: Julie Dawson

Process Sheet

Customer : CU-DAR001 Dart Helicopters Services	Drawing Name : AFT CAP
Job Number : 48109	
Estimate Number : 10312	
P.O. Number :	Part Number : D2646
This Issue : 22/05/2009 S.O. No. :	Drawing Number : D2646 REV C
Prsht Rev. : NC	Project Number : N/A
First Issue : / / Type : PURCHASED PARTS	Drawing Revision : C
Previous Run : 46327	Material :
Written By :	Due Date : 28/05/2009 Qty: 50 Um: Each
Checked & Approved By : <u>Julie Dawson</u>	
Comment : Est: G 05.08.22 Hole size revised in Step 5 KJ/JLM	
Est Rev:H Changed Inserts 07-02-19 JLM	
est rev I changed inserts 07.06.11 EC	

Additional Product

Job Number:



Seq. #:	Machine Or Operation:	Description :
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1.0	PG	PURCHASING
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**Comment:** PURCHASINGIssue P/O: 8855

C 209/05/26

1-Spin as per Dwg D2646

(50)

2-Material release note required

2.0	D2646P	Aft Cap
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Comment: Qty.: 1.0000 Each(s)/Unit Total : 50.0000 Each(s)
 AFT CAP

3.0	PACKAGING 1	PACKAGING RESOURCE #1
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**Comment:** PACKAGING RESOURCE #1

Receive & Inspect for Transit Damage

Ensure Material Release Note is attached

P/O 9/6/3 (50)

4.0	QC6	DIMENSIONAL CHECK
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**Comment:** DIMENSIONAL CHECK

Inspect dimensions as per Dwg D2646

S 02/06/09 (50)

5.0	SMALL FAB 1	SMALL & MEDIUM FAB RESOURCE 1
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**Comment:** SMALL & MEDIUM FAB RESOURCE 1

1-Drill using DT8026 as per Dwg D2646.

C 209/06/09 (50)

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 8:58:45 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 48109

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

2-Open holes to .297 as per Dwg D2646.

3-Deburr

6.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

2509/06/09 (50)
contin
509/06/09 (50)

7.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Acid etch and Alodine as per QSI 005 4.1

BR 09-06-11 (50)

8.0

POWDER COATING

POWDER COATING



Comment: POWDER COATING

Powder Coat White Gloss (Ref: 4.3.5.1) as per QSI 005 4.3

START TIME: 7:40 AM
OVEN TEMPERATURE: 370°F
FINISH TIME: 8:10 AM

M111472

all 09-06-17 (50)

9.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

BR 09-06-17 (50)

10.0

ALS71032130

Insert



Comment: Qty.: 2.0000 Each(s)/Unit Total : 100.0000 Each(s)

INSERT

Batch: M110511

UMO 09/06/22

11.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Install inserts as per Dwg D2646

UMO 09/06/22

12.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

contin
509/06/23 (50)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Friday, 22/05/2009 8:58:45 AM
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Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: AFT CAP

Job Number: 48109

Part Number: D2646

Job Number:



Seq. #:

Machine Or Operation:

Description :

13.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: FP-5

ell

09-06-23

(X50)

14.0

QC21

FINAL INSPECTION/W/O RELEASE



09/06/23

Comment: FINAL INSPECTION/W/O RELEASE

Job Completion



MF
09-06-23

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector



Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

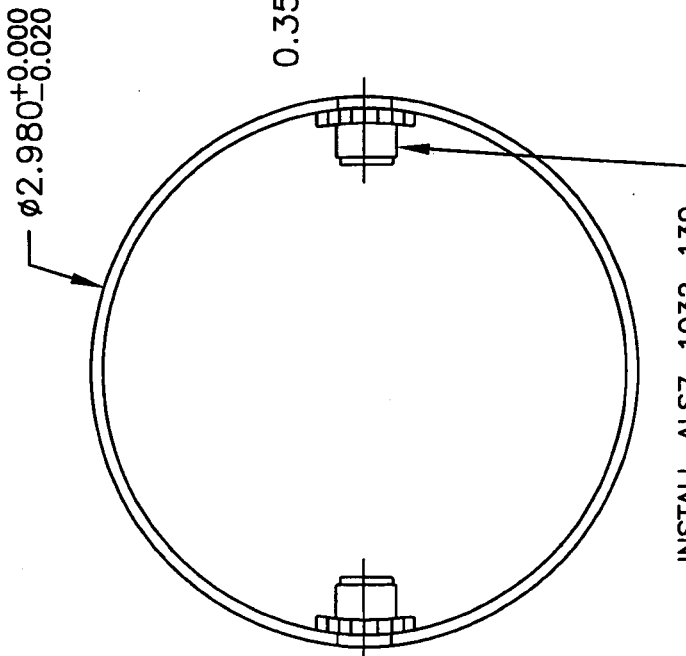
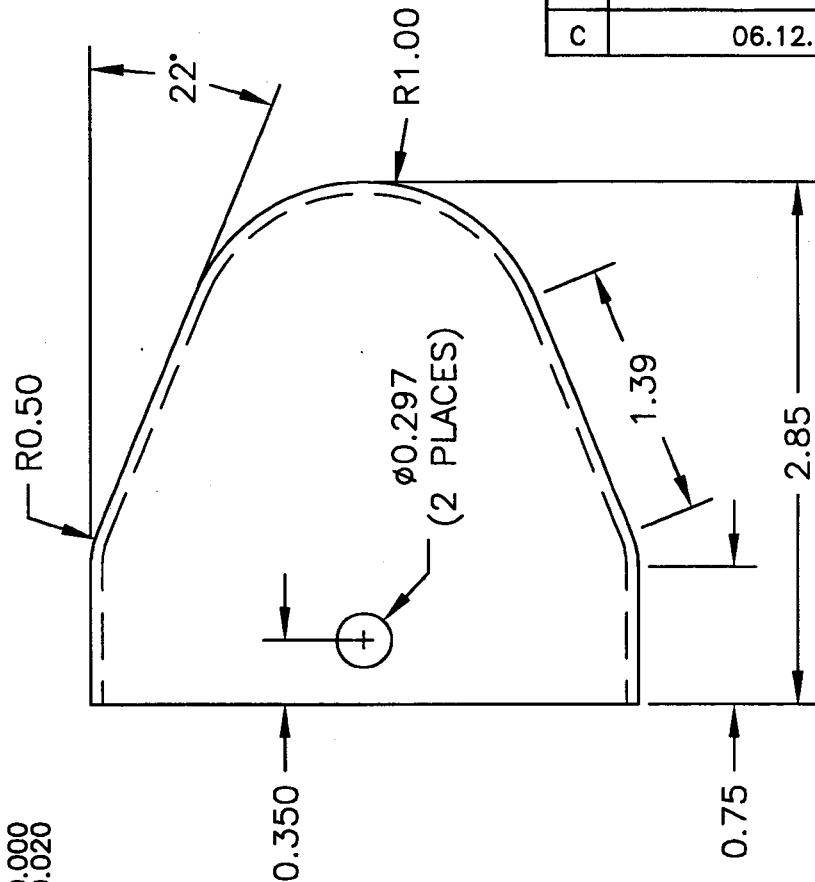
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN DS		DRAWN BY PH		DART AEROSPACE USA, INC. PORT HADLOCK, WA	
CHECKED 		APPROVED 		DRAWING NO. D2646	
DATE 06.12.20				REV. C SHEET 1 OF 1	
		TITLE AFT CAP		SCALE 1:1	
A	97.03.25		NEW ISSUE		
B	05.04.01		CHANGE TO CLOSED INSERTS		
C	06.12.20		CHANGE TO OPEN ENDED INSERTS		



INSTALL ALS7-1032-130
OR AKS4-1032-130
OR ALS4-1032-130
OR AELS-1032-130
INSERT AFTER FINISHING
(2 PLACES)

RELEASED

07.02.12 *[Signature]*

ALUMINUM 1100-0 0.063 THICK (QQ-A-250/1)
CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
DIMENSIONS ARE IN INCHES
TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

D2646 AFT CAP

- 1) MATERIAL
 - 2) FINISH
 - 3) ALL DIMENSIONS
 - 4) TOLERANCES
- INCONFORMITY REPORT
SUBJECT: AMENDMENT
WITH NOTICE
NO. 48109

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Comment:



Sieg's Manufacturing Ltd.

Metal Spinning and Fabricating

6236 - 205 STREET, LANGLEY, B.C. V2Y 1N7
TELEPHONE: (604) 530-7455 • FAX: (604) 530-7490

INSPECTION REPORT

Date: June 2/09

Customer: Dart Aerospace.

Packing Slip: 36743

Part#:	Quantity	Material	Check holes	Debur edges	Insp. By.
D2646P	50	14G1100	N/A	✓	<i>[Signature]</i>

Notes:

S. S. S. S. S.

Material Certification Attached: Yes

Verified by ThyssenKrupp Materials NA, Anna Riggs

Quantity: 3154 LB

Cust PO#: 717

Customer: SIEGS MANUFACTURING LTD. ***

(1 of 1)

2008-04-21

Shipper#: U47541

Cust Part#:

PRECISION COIL, INC.

Post Office Box 2650
U.S. 50 West
Clarksburg, WV 26302
(304) 622-1984
(304) 622-2301

7/10/2007

CS 1775

CERTIFIED INSPECTION REPORT

Report No. 31657

Test Date 7/10/2007

Lot # / Heat # / S/O # 76086

Alloy 1100

Temper O

Gauge (in) .063

Width (in) 48

Length (in) 144.000

Net Weight (lbs) 10,522# 'S

Customer Name COPPER & BRASS SALES

Customer PO # CS1775

Test Specification AMSQQA250/1A &
ASTMB209-06

Sorbel

Test No Spec ID YLD (psi) UTS (psi) ELONG in 2" (%)
38480 1100-O 5,714 13,038 33.00

ALLOY	Si	Fe	Cu	Mn	Mg	Cr	Zn	Ti	OTHER		Al
									EACH	TOTAL	
1100	Si+Fe	≤.95	.05-.20	.05	---	---	.10	---	.05	.15	89.00 Min
ACTUALS											
	.12	.60	.10	----	----	----	.01	----	.05	.15	REMAINDER

THIS REPORT INDICATES THE CHEMICAL ANALYSIS RANGE TO WHICH THE ITEMS LISTED WERE MANUFACTURED
BASED ON CERTIFICATE OF COMPLIANCE FURNISHED TO US BY THE PRODUCER. WE CERTIFY THEM TO BE
WITHIN THE LIMITS SHOWN. FOR ALLOY 1350 ONLY A MINIMUM ELECTRICAL CONDUCTIVITY OF 62% I.A.C.S.
AT 20 DEGREES CELSIUS IS GUARANTEED.

By: UNG Date: 7/13/07